

Date: Monday, 11/05/2009 1:20:55 PM  
 User: Julie Dawson

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: FRAME		
Job Number	47844			Part Number	: D22529		
Estimate Number	13821			Drawing Number	: D2252 REV G		
P.O. Number	:			Project Number	: N/A		
This Issue	11/05/2009 S.O. No. :			Drawing Revision	: G		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : LARGE FAB ASSY			Due Date	: 22/05/2009 Qty: 2 Um: Each		
Previous Run	46830						
Written By	:						
Checked & Approved By	<u>JLD 09.05.11</u>						
Comment	: Est Rev:A 09.03.18 New Issue EC verified by:DD						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W	
		Comment: Qty.: 0.8978 f(s)/Unit Total : 1.7955 f(s) 304 SQ Tube .75x.75x.065W batch: <u>M111432</u>	<u>SAD 09-05-20</u>
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1  1- Cut as per dwg D2252 2- Deburr and remove identification markings on tube	<u>SAD 09-05-20</u> (2)
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<u>SAD 09-05-21</u> (2)
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>Basket</u>	<u>PD 09-05-22 (2)</u>
5.0	QC21	FINAL INSPECTION/W/O RELEASE	
		Comment: FINAL INSPECTION/W/O RELEASE	<u>09/05/26</u> (2)
Job Completion			<u>6 09.05.22</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2252-041	BASKET ASSEMBLY
3		X	D2252-043	LID ASSEMBLY
7	2	2	D2221-1	RIB
8	5		D2235-1	RIB
9	2	2	D2252-1	FRAME
10		2	D2252-7	FRAME
11	1		D2252-9	FRAME
12	1		D2252-11	FRAME
13	1		D2252-13	FRAME
14	1		D2252-15	FRAME
15	4		D2252-17	FRAME
16		1	D2252-23	FRAME
17	2		D2253-1	LUG
18	2		D2254	GUSSET
19	1	1	D2327-3	BUSHING
20		1	D2329	LABEL PLATE
21	4	2	D2581	MOUNTING CHANNEL
22		2	D2989-19	RIB
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF

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- NOTES:  
 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
     REF. DART SPEC M304TS0.750W.065  
 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
     REF DART SPEC M304EX0.75-16F  
 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3  
 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 5) UNITS: INCHES UNLESS OTHERWISE NOTED  
 6) BREAK SHARP EDGES: N/A  
 7) IDENTIFICATION: N/A  
 8) WEIGHT: N/A  
 9) WELDING: PER DART QSI 004

8 7 6 5 4 3 2 1

G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (ZN A6-5). P/N REASON: SEE PAR#09-006.		MB	09.02.03
	REV.	DESCRIPTION		
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060.		AJS	08.08.11
E	INCORPORATED D1 & D2. ADDED D2231-1/3 & D2252-19.		MB	05.11.10
D	MODIFIED LATCH, D2581 WAS D2255-3		BK	99.09.14
C	RE-DRAWN		BK	95.12.11
REV.	DESCRIPTION	BY	DATE	
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		DRAWING NO. D2252		
CHECKED		REV. G SHEET 1 OF 6		
MFG. APPR.		TITLE		
APPROVED		SCALE		
DE APPR.		NTS		
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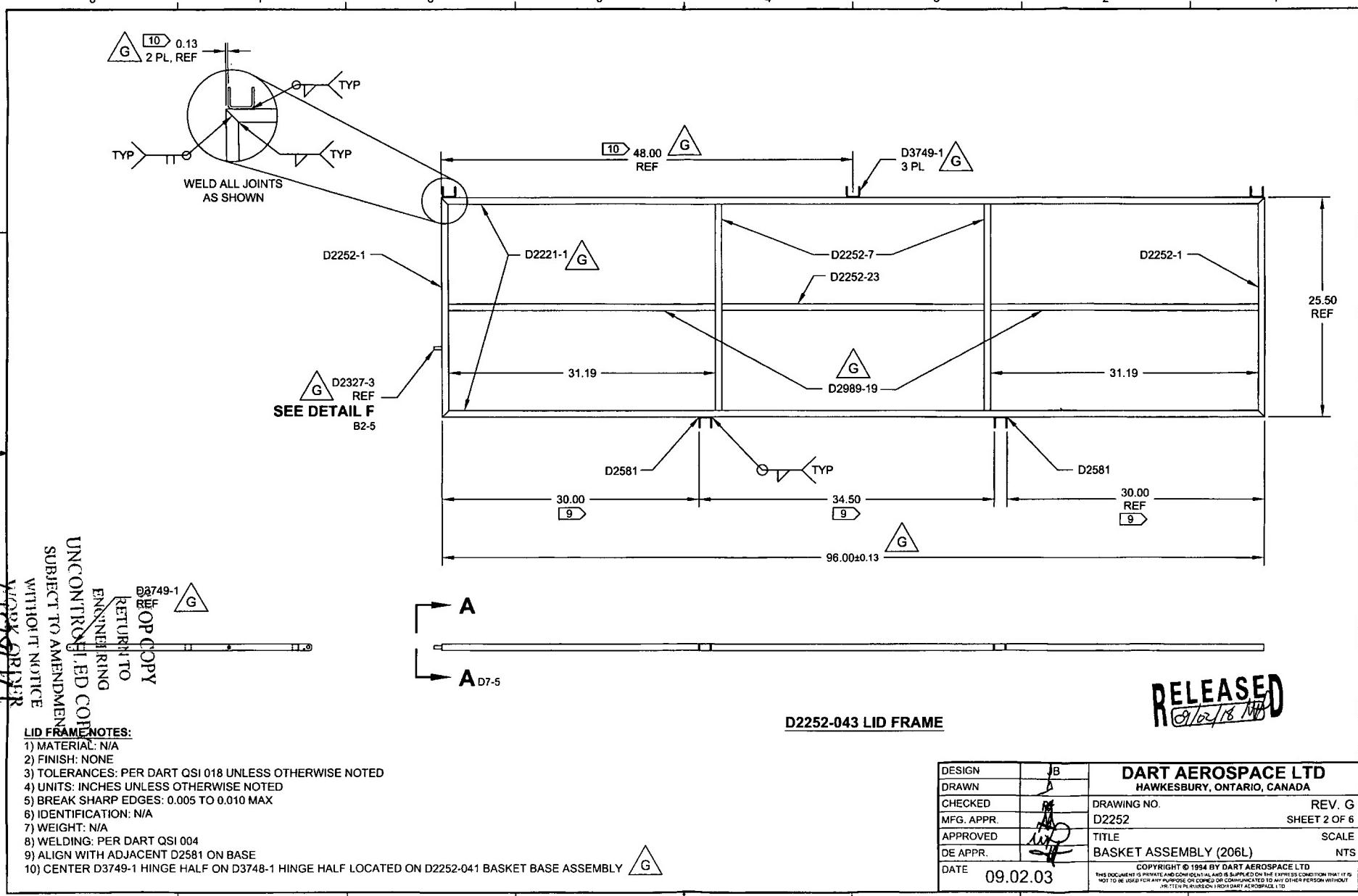
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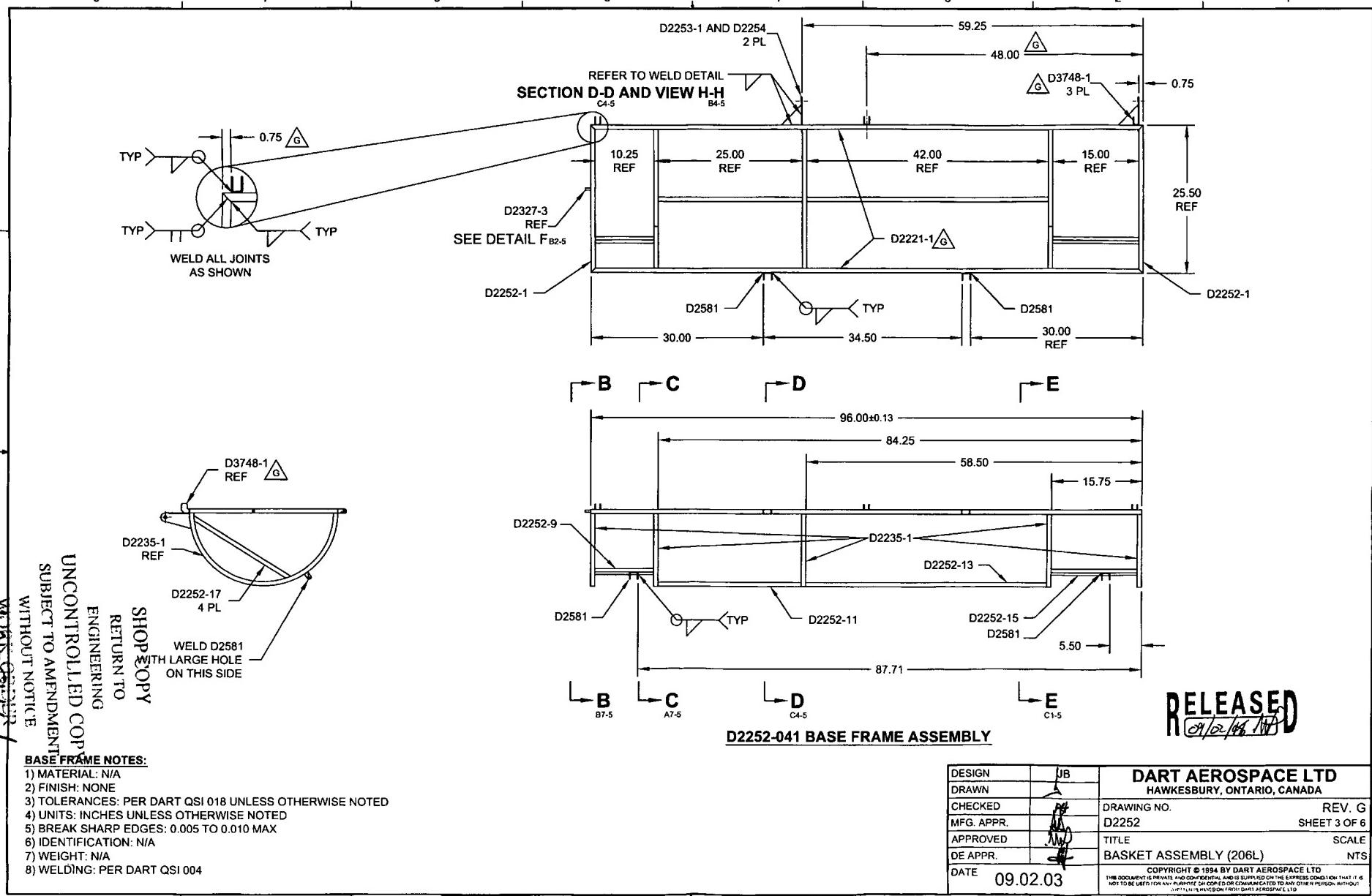
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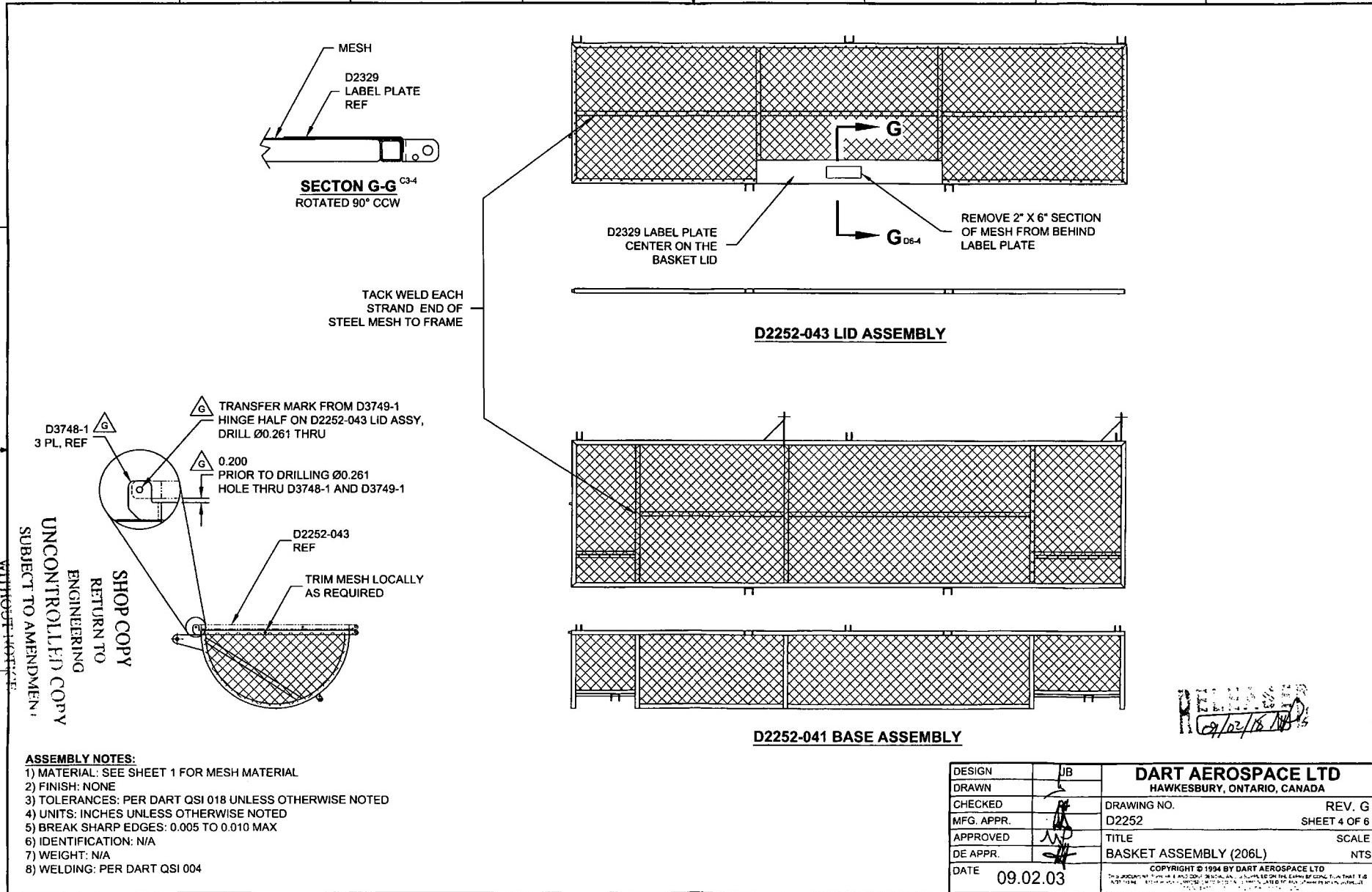




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DRAWN		HAWKESBURY, ONTARIO, CANADA
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DATE	09.02.03	SCALE
		BASKET ASSEMBLY (206L)
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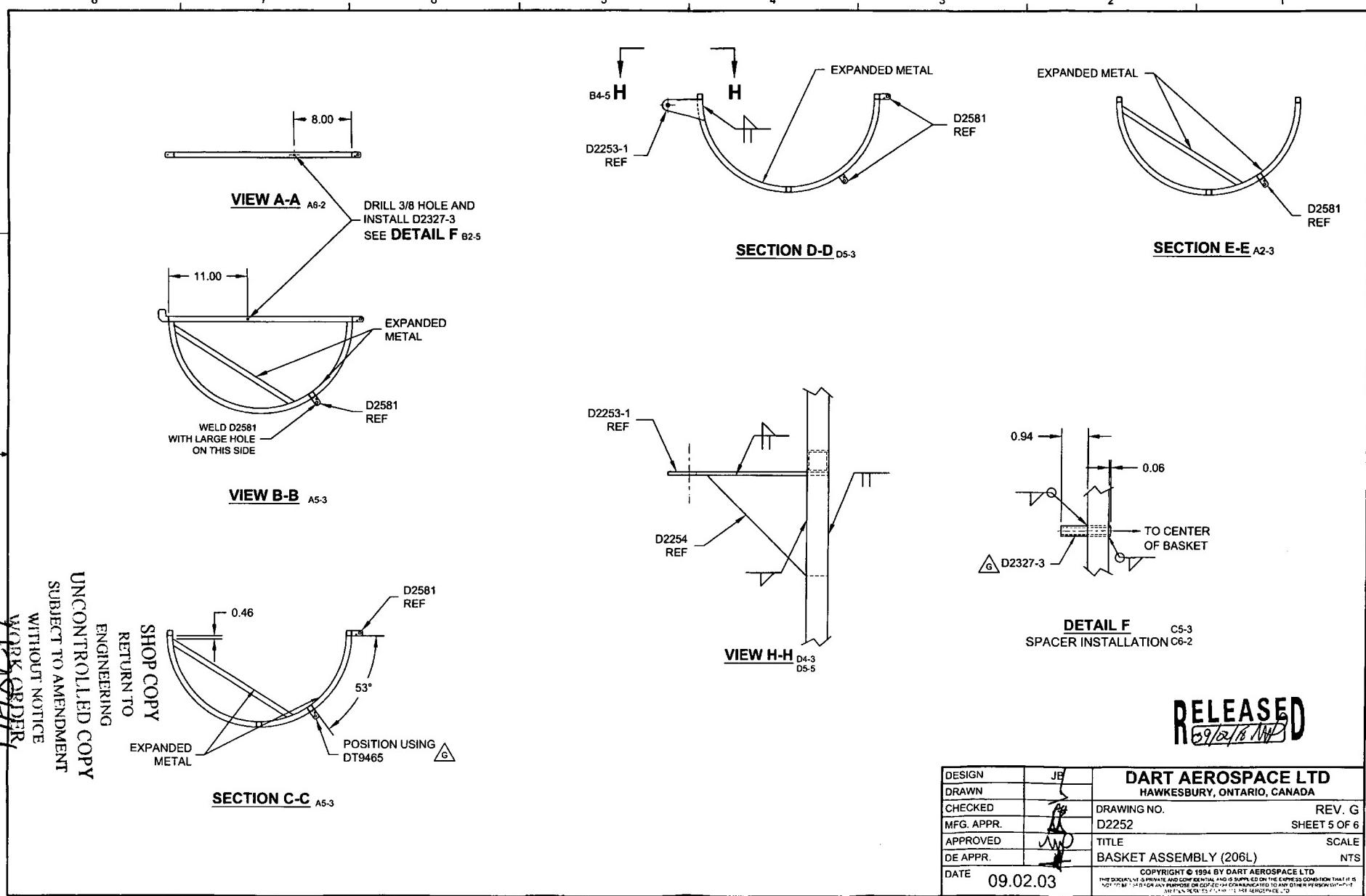
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## **ASSEMBLY NOTES:**

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A
  - 8) WELDING: PER DART QSI 004

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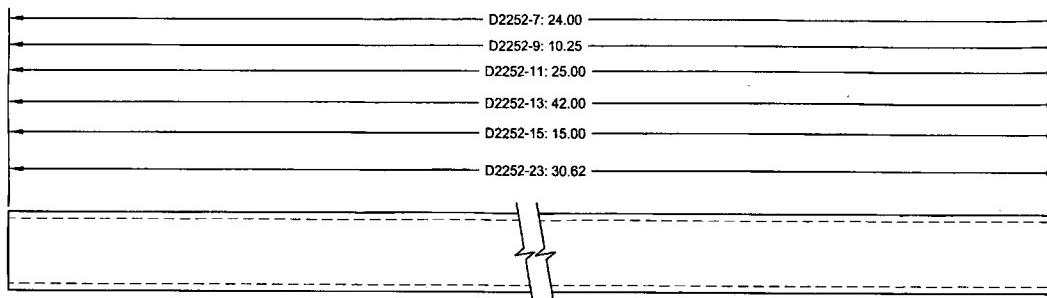
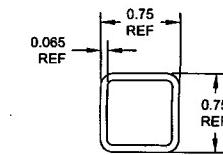


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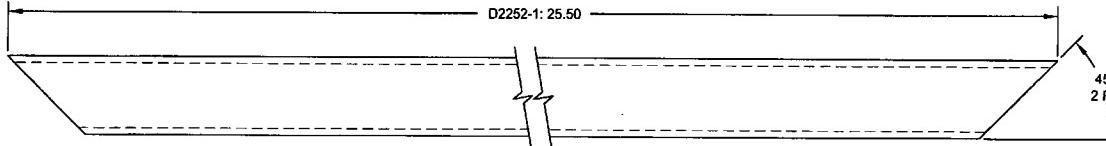
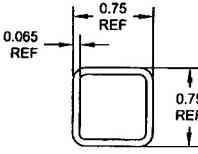
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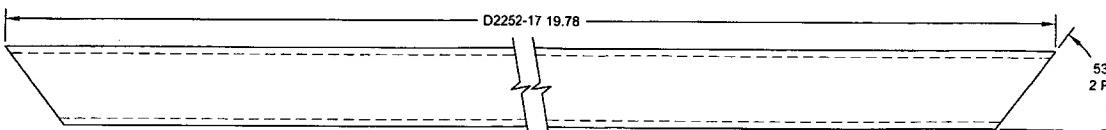
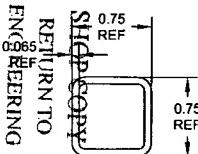
D2252-7 FRAME  
D2252-9 FRAME  
D2252-11 FRAME  
D2252-13 FRAME  
D2252-15 FRAME  
D2252-23 FRAME

C



D2252-1 FRAME

B



D2252-17 FRAME

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NOTES:  
 1) FRAME MATERIAL: SEE SHEET 1  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
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